

Work Order ID 81255***81255***

Page 1

March-12-12 1:54:20 PM

Item ID: D3929-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Gusset Assembly

Start Date: 12/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 16/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12/03/12 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3929

Rev A

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3929

Dwg Rev: AProg Rev: A

2-Deburr if necessary

B/2-3-20

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B/2-3-20

W/O:		WORK ORDER CHANGES					
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Date:

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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

12/03/21 SRR

140

0.00

140

Large Fab

Memo

0.00

Large Fab

Weld bushings D3907-1 as per dwg D3929

316L rod batch: M115778

12.04.09 ⑦

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

150

QC

Memo

0.00

Quality Control

BE 12.04.10 1 φ

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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: B.C. 0.00***170***

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release 0.00

180

QC

Memo

0.00

Quality Control

12/4/10

12-04-10

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Picklist Print

March-12-12 1:54:24 PM

Page 1

Work Order ID: 81255

81255

Parent Item: D3929-041

D3929-041

Parent Item Name: Gusset Assembly

Start Date: 12/03/2012

Required Date: 16/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	31.1000	0.45	2.842105			

M304S11GA

304/316 0.125 Sheet

**

B12-3-20

Location

Loc Qty

Loc Code

MAT020

31.1

120243

26

120604

5.1

120243

(7)

D3907-1

Manufactured

No

130

Each

43.0000

2

12

**

D3907-1

Bushing

Location

Loc Qty

Loc Code

WA

43

73008

3

79121

40

81470

14

12.04.09

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Dart Aerospace Ltd

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ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 8125 MLJ
12/03/12

D3929-041 GUSSET ASSEMBLY

D3929-042 GUSSET ASSEMBLY

RELEASED
8/6/12 MLJ

- NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.73 lbs EACH
8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	09.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.03		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3929	REV. A SHEET 1 OF 3
TITLE GUSSET ASSEMBLY	SCALE NTS
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W/O:		WORK ORDER CHANGES					
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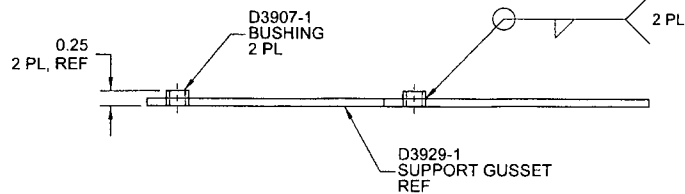
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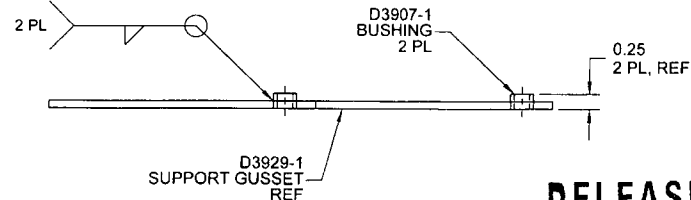
D3929-1
SUPPORT GUSSET
2 PL



D3929-041 GUSSET ASSEMBLY

81255

D3929-1
SUPPORT GUSSET
2 PL



D3929-042 GUSSET ASSEMBLY

RELEASED
09/04/22

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 2 OF 3
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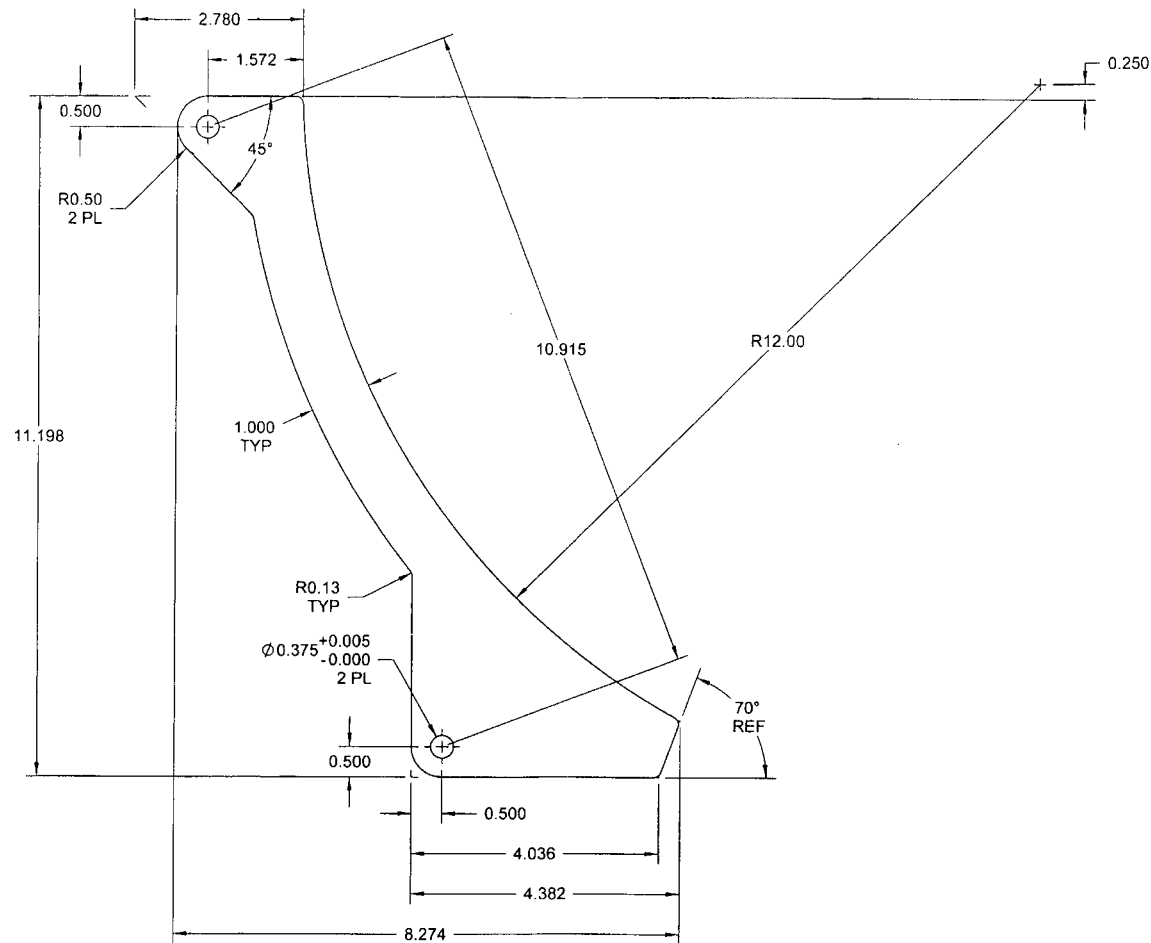
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


D3929-1 SUPPORT GUSSET

RELEASED
9/04/22 JMD

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 3 OF 4
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